

Work Order ID 71141

Thursday, June 23, 2011 12:32:50 PM



Item ID: D3234-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/23/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 11-06-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3234	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3234 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

Deburr if necessary

2524.050

B11-6-27

8

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-27

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sul6/27

48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Bx ✓ M-11/06/27

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

B BR 11-6-27

150

Identify as per dwg & Stock Location: 233

0.00



Packaging

Memo

0.00

Packaging

Rec'd 8/28 (8)

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Page 3

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Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
Number Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28 JJ

ME

11-06-28

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Picklist Print

Thursday, June 23, 2011 12:32:46 PM

Page 1

Work Order ID: 71141



Parent Item: D3234-3



Parent Item Name: Doubler



Start Date: 6/23/2011

Required Date: 7/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC
IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	116.3000	0.2165	1.367368			
													

2024-T3 .050 sheet

B11-6-07

Location

Loc Qty

Loc Code

MAT22

116.3

117684

116.3

117684

8

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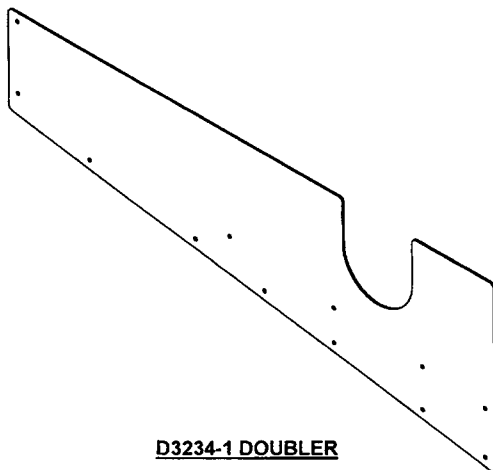
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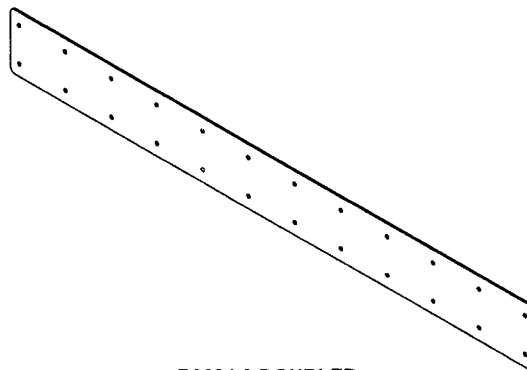
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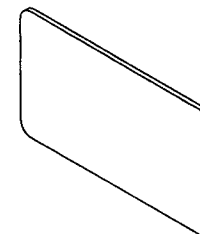
NOTE: Date & initial all entries



D3234-1 DOUBLER



D3234-3 DOUBLER



D3234-5 SPACER

NOTES:

1) MATERIAL: -1 & -3: 2024-T3 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF DART SPEC M5052H32S.050

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3234-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: -1: 0.30 lbs
-3: 0.15 lbs
-5: 0.01 lbs

71141

RELEASED
08/12/15 IN

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D3234	SHEET 1 OF 2
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	DOUBLER	NTS
DATE	08.11.24	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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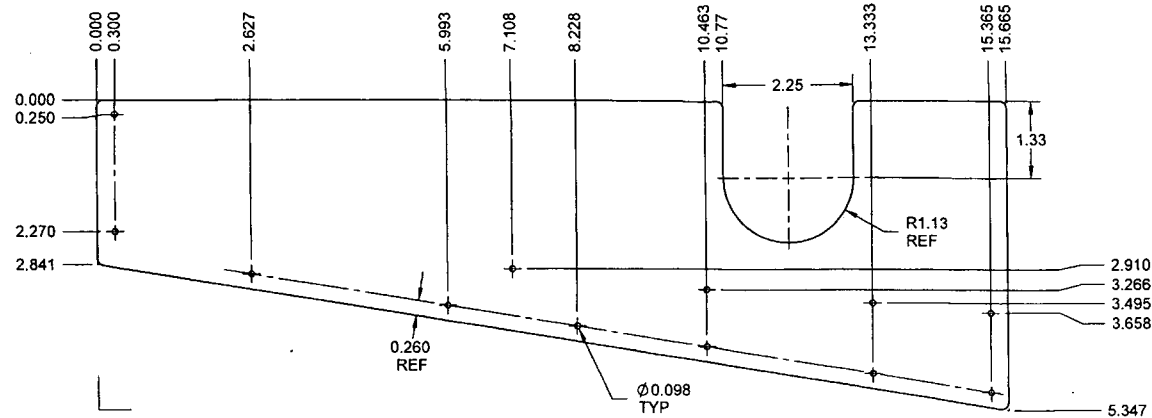
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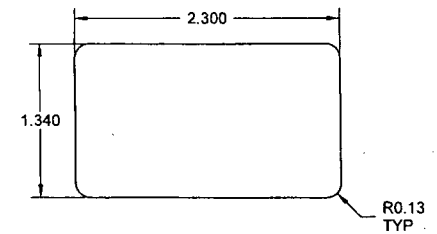
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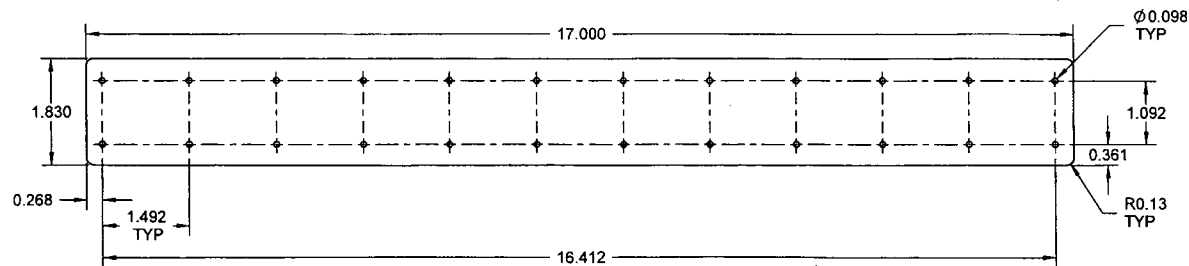
8 7 6 5 4 3 2 1



D3234-1 DOUBLER







D3234-5 SPACER



D3234-3 DOUBLER

#71141

RELEASED
08/12/15

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3234	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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8 7 6 5 4 3 2 1

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